

ASAP

Dart Aerospace Ltd.

Date: Thursday, 12/06/2008 9:46:02 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 39826	
Estimate Number : 10930	
P.O. Number :	Part Number : D2057
This Issue : 12/06/2008 S.O. No. :	Drawing Number : D2057 PRELIM <i>PH</i> <i>08-06-12</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : PRELIM
Previous Run : 39661	Material :
Written By : _____	Due Date : 19/06/2008 Qty: 100 Um: Each
Checked & Approved By : _____	
Comment : Est D 02.08.22 Make in Cobra KJ Est Rev:E 08-05-27 as per ECN1195P DD verified by:EC Est Rev:F 08-06-04 Added QC8 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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(100)



Comment: Qty.: 0.1050 f(s)/Unit Total : 10.5000 f(s)
 6061-T6 Round Bar .750"
 Material: 6061-T6 (QQ-A-225/8) Ø0.75 Rod
 (M6061T6R0.750) Batch *M102857 mme 08/06/13*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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(100)



Comment: HARDINGE CNC LATHE SMALL
 Make as per Dwg D2057 and Folio FA260.
 Break all sharp edges 0.015 max. Do not drill Ø0.191

DIP/mme 08/06/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*DIP/mme 08/06/13***Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*mme 08/06/13*

(100)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock
 Location: *ST10*

08/06/13 (100)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector




Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

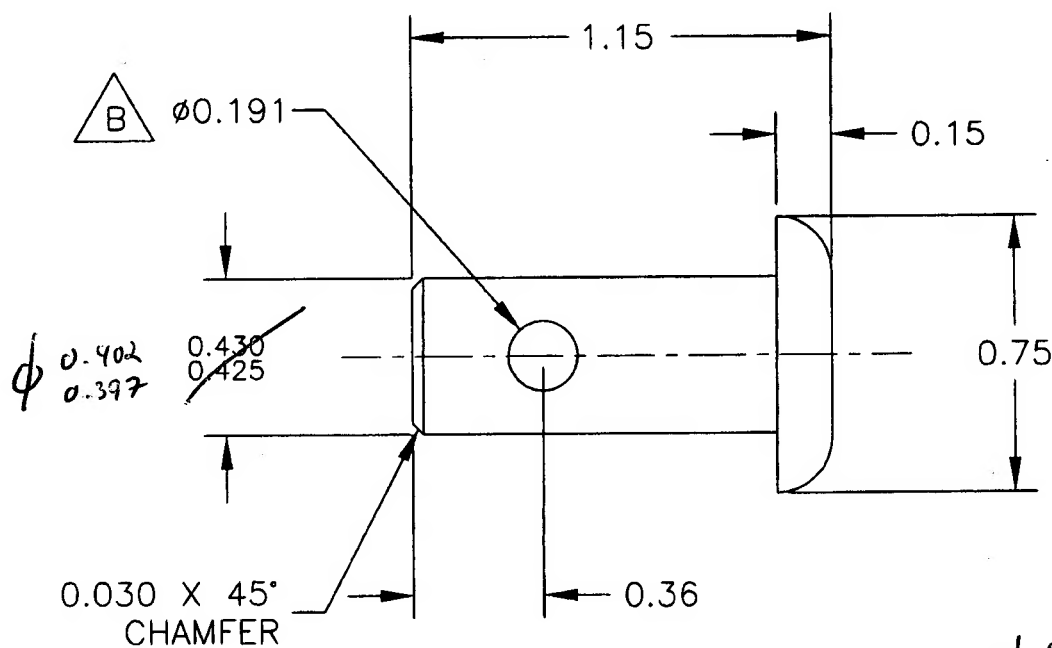
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN JB		DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2057		REV. B SHEET 1 OF 1
DATE 98.10.15		TITLE PLUG		SCALE 2:1
A	92.03.13	NEW ISSUE		
B	98.10.15	REDRAWN 0.191 DIA WAS 0.187 DIA (TSR A1100)		

RELEASED
98.10.16 PS



Wb 39826

PD 08.06.12
UNDER REVIEW
08/08.27 PH
0.430/0.425 TO
BECOME SMALLER Dk
D2010-1037-104 IS
CHANGING

MATERIAL: 6061-T6 ROD (QQ-A-225/8)
FINISH: NONE
BREAK ALL SHARP EDGES 0.015 MAX
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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